

303 1000

Work Order ID 83613

April-20-12 1:25:07 PM

\*83613\*

Page 1

Item ID: D3954-1

Revision ID:

Item Name: GWT Pin

Start Date: 20/04/2012 Start Qty: 6.00

Required Date: 04/05/2012 Req'd Qty: 6.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 12/04/20

Tooling:

Date:

QC: \_\_\_\_\_

Date:

SPC (Y/N): \_\_\_\_\_

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3954	C								

100

0.00

\*100\*

Doosan

Doosan Lathe

Memo

1-Turn as per folio VA824 & dwg D3954

FOLIO REV: 44

DWG REV: C

2-Deburr as required

0.00

24 12-5-16

12 4

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

24 12-5-16

12 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*83613\***

Page 2

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**Start Date:** 20/04/2012    **Start Qty:** 6.00    **\*6\***

**Cust Item ID:**

**Required Date:** 04/05/2012      **Req'd Qty:** 6.00      **\*6\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

Identify as per dwg & Stock Location: 57 #4 0.00

0.00

**\*150\***

### Packaging

## Memo

0.00

### Packaging

QC21- Final Inspection - Work Order Release	0.00
---	------

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

April-20-12 1:25:11 PM

Page 1

Work Order ID: 83613

\*83613\*

Parent Item: D3954-1

\*D3954-1\*

Parent Item Name: GWT Pin

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No			100	f	39.3152	0.24	1.44			

\*M303R1 000\*

303 Round Bar 1.00

\*\*

22 2.5.12

Location

Loc Qty

Loc Code

MAT028

39.31515789

120866

12

121070

3.31515789

121282

24

121228

2.85

W/O:		WORK ORDER CHANGES					
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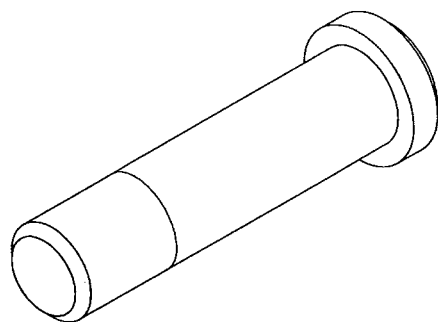
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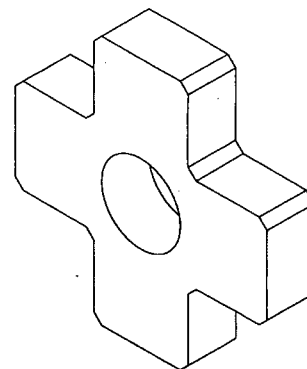
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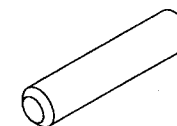




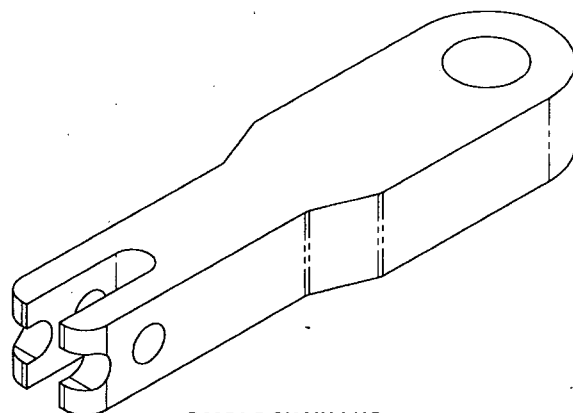
**D3954-1 GWT PIN**



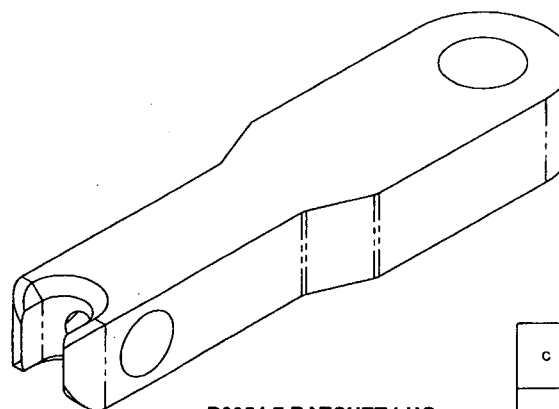
**D3954-3 GWT KNOB**



**D3954-9 GWT CHAIN PIN**



**D3954-5 CHAIN LUG**



**D3954-7 RATCHET LUG**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 83613 MLJ  
12/04/20

**RELEASED**  
2011-07-29

C	MATERIAL UPDATE FOR D3954-1/-3: NOW STAINLESS STEEL ONLY (A8-2); FINISH CHANGED TO "NONE" FOR D3954-1/-3 (A8-2); TOLERANCE ON Ø0.750 WAS Ø0.75 MAX (D3-3 & D7-3); D3954-9 NOW A PURCHASED PART (A2/A8-3). REASON: PAR11-113.	MB	11.07.27
B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS/DSTOW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3954	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	11.07.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

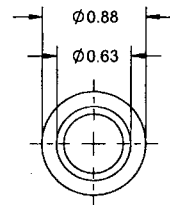
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

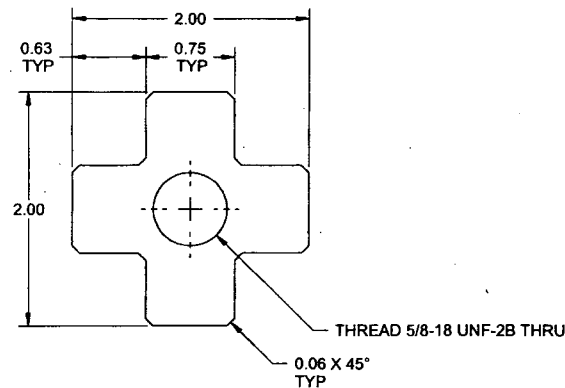
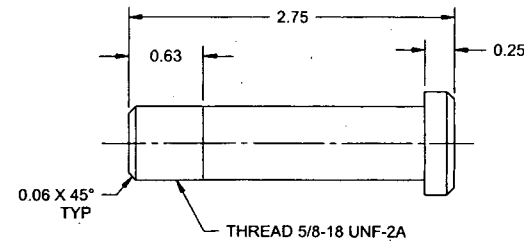
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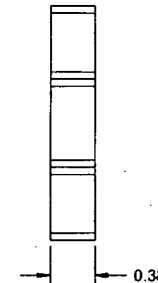
**NOTE:** Date & initial all entries



**D3954-1 GWT PIN**



**D3954-3 GWT KNOB**



**NOTES:**

- 1) MATERIAL -1: AISI 303/304/316 STAINLESS STEEL ROUND BAR  
PER ASTM A582 (303) OR ASTM A276 (304/316)  
REF DART SPEC M303R OR M304R
- 3: AISI 303/304/316 STAINLESS STEEL SHEET  
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)  
OR ASTM A240 OR ASME SA240  
REF DART SPEC M303S OR M304S
- OR:  
AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE  
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)  
REF DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -1: 0.26 lbs  
-3: 0.23 lbs

**RELEASED**  
2011-07-29

DESIGN	AJS/DSTOW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3954	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	11.07.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

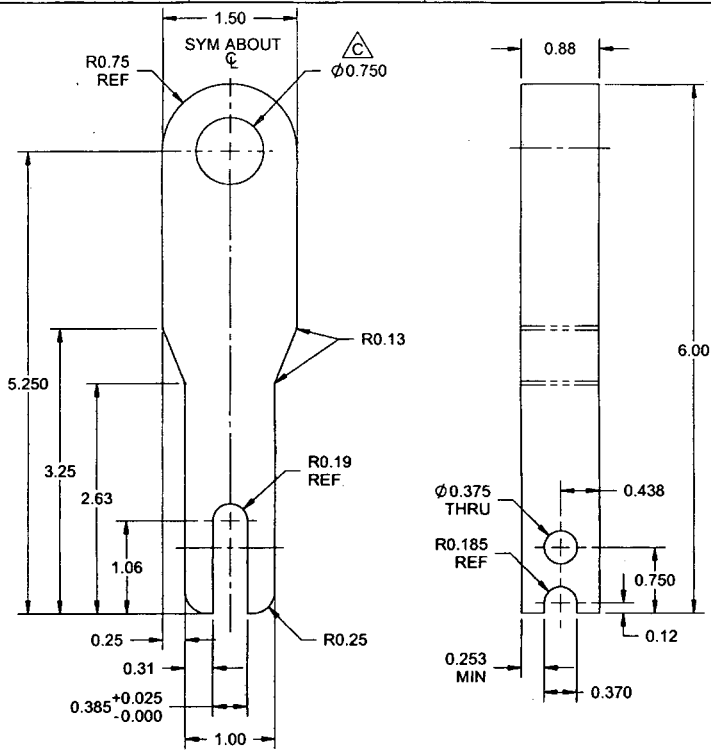
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

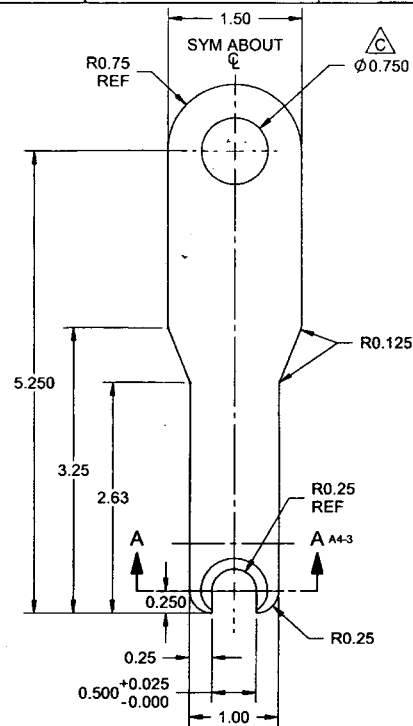
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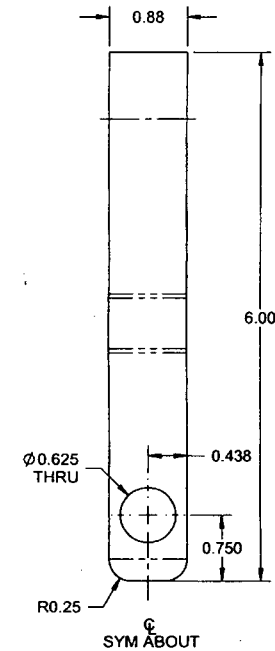
**NOTE:** Date & initial all entries



**D3954-5 CHAIN LUG**



**D3954-7 RATCHET LUG**



**D3954-9 GWT CHAIN PIN**

**NOTES:**

**1) MATERIAL:**

-5/-7: AISI 1010-1025 MILD STEEL BAR  
PER DART SPEC M1010-B

-9: PURCHASE PART FROM MCMASTER-CARR:  
P/N 98381A630 (MILD STEEL)

**ALTERNATE MATERIAL:**

-5/-7: AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE  
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)  
REF DART SPEC M303B OR M304B

-9: PURCHASE PART FROM MCMASTER-CARR:  
P/N 90145A630 (STAINLESS STEEL)

2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

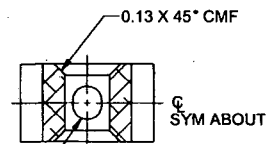
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

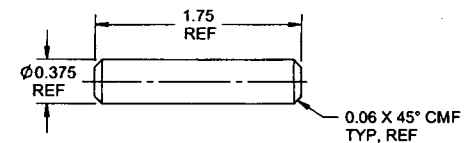
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -5/-7: 1.56 lbs EACH

-9: 0.05 lbs REF



**SECTION A-A C3-3**



DESIGN	AJS/DSTOW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. <b>D3954</b>	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	<b>MISC MACHINED PARTS GWT KIT</b>	NTS
DATE	11.07.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
2011-07-29

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